<b>Work Order</b> Monday, March 17	7, 2014 2:32:50 PM		*114					Page 1		
Revision ID:	3558-3 asket Center Fwd		Accept	*N900	<u>040</u>	100	)*	Setup Star Stop	171	S1* S2*
Start Date: 3/ Required Date: 3/ Reference:	17/14 Start Qty: 8.00 17/14 Req'd Qty: 8.00	, *8* *8*		Cust Item 1 Customer:	D:					. ,,
	Process Plan:	Date: \403-\&	Tooling: SPC (Y/N):		ate:		]	Run Star Stop	, ^IVI	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3558	Rev B									
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo  1-Cut as pe Deburr if no	or Dwg D3558 Dwg Rev:_ ecessary	0.00  8 0.00 Prog Rev: 8	2-			_12_	<u> </u>		JM14-04-6
*110 *11 <b>0</b> * oc	QC2- Inspect parts off n	nachine FAI/FAIB	0.00				12	&		Jm14-04-(
Quality Control  120  *1 20*	QC8- Inspect parts - sec	cond check	DAS 0.00 27 9 89				10			
QC	Memo		0.00 1414	7			12	_		

Quality Control

DQA: _		Date:											
QA Closed:		Date:			WORK ORDER NON-	-((	JNFOI	RIVIANCE / UPDA		ork Order up	odate only	AEROSPACE	
Mante Ondon		-	- "-		DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS		
Work Order:				—	Rework			Skid-tube Cro	osstube	1	Water Jet	T Engineering	
Part No	) <sub>-</sub>				Scrap			<del></del>	mall Fab	Pro	d. Eng. Coor.	Engineering Quality	
					Use-as-is		Thermoforming Finishing Rec/Store/Packaging					Other	
NCR No	)				Suspected Unapproved								
Root			<del></del>	Desci	ription of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector	
Design													
Doc/Data	_												
quip/Tooling													
Handling/Pre	_												
Material						ĺ							
Operator		1											
Offset/Setup													
Process													
Supplier													
Fraining										i			
Transport													
Jnapproved													
						FAI	ULT CAT	EGORY			•		
Landing	Gear				General		_			_			
L	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced	
	Centre No	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	i	Temperature/Cure	
	Crimp/Kin	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualif	fied	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/Unclea	ar 🗀	Part Moved		Wrong Stock Pulled	
	Crushing Countersink					Misalig	ned/off center		Positioned W	√rong	_		
	Heat Trea	it			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other	
Γ	Inspection Strip in Tube Drawing						Misread	I	<b></b>	•	_	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	
	Marks/Chatter Drill Holes					Off-set							
	Turning Sequence Finish					Out of Calibration							
	Wave/Twist in Tube Fit/Function				Fit/Function		Out of 9	Sequence					

Work	Order ID	114050
WOLK	Oraer III	114730

Monday, March 17, 2014 2:32:50 PM				*112					Page 2			
Item ID: Revision ID:	D3558-3		· A	Accept	*N900	<b>040</b>	100	)*	Setup	Start		<b>S1</b> *
Item Name:	Gasket Cente	er Fwd								Stop	*N.	<b>S2*</b>
Start Date:	3/17/14	Start Qty: 8.00	*8*		Cust Item II	D:						
Required Date:	3/17/14	<b>Req'd Qty:</b> 8.00	*8*		Customer:							
Reference:					1		_		_	G		
Approvals:	Process Pl	an:	Date:	Tooling:	Da	te:			Run	Start	*NI	<b>२</b> 1*
	QC:		Date:	<b>SPC</b> (Y/N):	Da	te:				Stop	*NI	₹2*
Sequence ID/ Work Center I	D	Operation Description	FD and	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130		Identify as per dwg & St	ock Location: [P-60]	0.00				/ .	•	$\int$ (	100	1 /
*120* Packaging		Memo		0.00				X(2		)	<u>ru</u> 1	<u> 110 11 C</u>
Packaging					•							
140		QC21- Final Inspection	- Work Order Release	0.00				*			. ^	. G
*14 <b>0</b> *		Мето		0.00				M(	٢_	14-	0Y- C	
Quality Control									_			
										(~)	60	

CH1404-07

DQA:			Date:			· •								
			<b>.</b> .			WORK ORDER NON-	-CC	ONFO	RMANCE / UI				_	AEROSPACE
QA Closed:			Date:							w	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	-					Rework	Skid-tube Crosstube Water Jet Engine						Engineering	
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thermoforming Finishing Rec/Store/Packaging Othe					Other	
NCR N	۱o					Suspected Unapproved		Large Fab Composite Supplier						
Root					Desc	ription of work order update	П	nitial	Act	ion	Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC Inspector
Design														
Doc/Data											i			
Equip/Tooling			•	1					ļ					
Handling/Pre					}									
Material														
Operator	Ш													
Offset/Setup	Ш			·										
Process	Ц						1							
Supplier	Ш								}					
Training	Ш												1	
Transport	Ц													
Unapproved			<u> </u>	<u> </u>	<u> </u>									
							FA	ULT CAT	regory					
Landi						General	_	ı .		_	7	г		
	_	Bending			<u> </u>	Bend		1 `	rogram	ļ	Outside Dim		_	essure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u></u>	Over/Under		_	et-up
,	Н	Cracks				Broken/Damage/Defect	<u></u>	Hardwa		<u> </u>	Part Incorred		_	emperature/Cure
	-	Crimp/Kir	nk/Ripple	:/Wave	-	Burrs		<b>-</b> i	ion Incomplete/Ur	· —	Part Lost/Mi	ssing	_	'eld
		Cuffs			<u> </u>	Contamination	<u> </u>	-	tions Incomplete/U	Jnclear	Part Moved	L	\w	rong Stock Pulled
	${m -}$	Crushing			<u> </u>	Countersink	<u>_</u>	-	gned/off center	ļ	Positioned V		_	
		Heat Trea			<u> </u>	Cut Too Short	$\vdash$	Mislabe			Power Loss/	Surge	0	ther
	$\vdash$	Inspectio	•	Tube	_	Drawing	<u> </u>	Misread						
	-	Marks/Ch			<u> </u>	Drill Holes	_	Off-set						
	-	Turning S				Finish		Out of Calibration						
l	1 1	Wave/Twist in Tube     Fit/Function					1	Out of	Sequence					

Page 1

Order ID: 114950

\*114950\*

Item:

D3558-3

\*D3558-3\*

t Item Name:

Gasket Center Fwd

**Start Date:** 3/17/14

Required Date: 3/17/14

Start Oty: 8.00

Required Qty: 8.00

nments:

IPP Rev:A New Issue 06-12-15 JLM Ets Rev:B Rev B dwg 07-12-06 DD

mponent Item ID/ em Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NEO60S.063		Purchased	No		100	sf	1,129.100	0.7522	6.686222			
NANIFORC	C 060*							**	8		ふ	m14-04.

\*MNF()60S()63\* NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code	
MAT052	1129.1		
M126546	27.1		
M128266	302		198700
M128339	800		

QA:			Date: _												
<b>-</b> ·			<u>.</u>			WORK ORDER NON-CONFORMANCE / UPDATE								A E R	
QA Closed:			Date:					<u> </u>			W	ork Order u	pdate only	<u> </u>	
Work Order	•					DISPOSITION	SITION AGAINST DEPARTMENT/PROCESS								
	_				_	Rework	vork Skid-tube Crosstube Water Jet						t	Engineerin	
Part No	). 					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor	-	Quality
						Use-as-is		Therr	noforming	Finishing	<u> </u>	Rec/Sto	re/Packagin	g	Other
NCR No	o. <u> </u>	······································				Suspected Unapproved		<u> </u>	Large Fab Composite Supplier			r	]		
Root	Т	I	1		Desci	ription of work order update		Initial	Δι	ction		Sign &	ſ	-	<u></u>
Cause		Date	Step	Qty		or non-conformance	1	nief Eng	-	cription		Date	Verificati	on	QC Inspec
Design	$\top$									1					
Doc/Data	1														
Equip/Tooling		ļ													
Handling/Pre		İ													
Material															
Operator															
Offset/Setup															
Process	4														
Supplier															
Training	4														
Transport	4														
Unapproved															
							FA	ULT CA	TEGORY						,
Landing						General 1	_	7			_	7		_	7
-		ending			<u> </u>	Bend	L	-	Program		_	Outside Dim			Pressure/Force
	_	entre No	t Concen	ntric	<u> </u>	BOM/Route	L	Grain			$\vdash$	Over/Under tolerance		<u></u>	Set-up
-	_	racks	l /n: '		<u> </u>	Broken/Damage/Defect	L	Hardwa			-	Part Incorre			Temperature/0
-	┥.	rimp/Kin	k/Ripple,	/Wave	<u> </u>	Burrs	$\vdash$	┪ '	Inspection Incomplete/Unqualified		$\vdash$	Part Lost/Missing		$\perp$	Weld
-	Contamination		$\vdash$	Instructions Incomplete/Unclear		$\vdash$	<del></del>		Wrong Stock P						
-	—1	rushing			<u> </u>	Countersink	<u> </u>	┪ ゚	gned/off center	•	$\vdash$	Positioned \	-	_	7
	_	eat Treat		<del>-</del> 1	<u> </u>	Cut Too Short	_	Mislabe				Power Loss/	'Surge	L	Other
}		spection		Tube	<u> </u>	Drawing		Misrea							
-		1arks/Cha				Drill Holes	<u> </u>	Off-set							
F	Turning Sequence Finish Wave/Twist in Tube Fit/Function			Out of Sequence					***						
1	I۷	/ave/Twi	st in Tub	e e		Fit/Function	1	IOut of	Saguence						

DART AEROSPACE LTD	Work Order:	114950
Description: Gasket	Part Number:	D3558-3
Inspection Dwg: D3558 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.19	_		V	Jhmo S
0.30	+/-0.030	0.30			V	
0.30	+/-0.030	0.30"	_		V	
0.38	+/-0.030	0.38	·		V	
2.73	+/-0.030	2.73'			V	
2.06	+/-0.030	2.06"			V	
5.63	+/-0.030	5,63	-		v	
33.75	+/-0.030	33.75			T	Them07
36.13	+/-0.030	36.13			7	
			÷			
			DAS			

			27		
Measured by:	Jm	Audited by:	9-89	Prototype Approval:	N/A
Date:	14-04-6.	Date:	141417	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM 1.A	
В	08.04.17	Dimensions updated per Dwg Rev B	KJ/DD 🚜	<i>X</i>

